

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007777**Date Inspected:** 20-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

1AAW Segment

SMAW welding of spacer blocks at various locations.

Welder is identified as Mr. Lud Xuanping (067610). ZPMC QC is identified as Mr. Cheng Xi.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

4BW &amp; 5AW Segment

FCAW welding of LD located between panel points 26 and 25.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-Repair.

1BW &amp; 2AW Segment

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SMAW welding of base metal located at weld splice joint.

Welder is identified as Mr. Xia Jun (068253). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair.

### 4BW Segment

SMAW plug welding of horizontal stiffeners located on panel point 26.

Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair.

### 3AW Segment

SMAW welding of stiffeners located on side plate on counter weight side.

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

### NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trail assembly yard. Locations are as followed:

1. Side Plate stiffeners at panel point 24 on Segment 4AW (crossbeam side).
2. Side Plate stiffeners at panel point 18 on Segment 2BE (crossbeam side).
3. Side Plate stiffeners at panel point 18 on Segment 2BW (counter weight side).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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